

Date: Thursday, 7/3/2008 3:38:30 PM
 User: Kim Johnston

Process Sheet

29

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKID LH 206L1,L3,L4&407
 Job Number : 40237
 Estimate Number : 10307
 P.O. Number :
 This Issue : 7/3/2008 S.O. No. :
 Prsht Rev. : NC Drawing Number : N/A
 First Issue : / / Type : SKIDTUBES Project Number : N/A
 Previous Run : 40236 Material : L
 Due Date : 7/17/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment :
 Est Rev: B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 Est Rev: C 07-02-23 As per IIN D206-642 Rev K JLM
 est rev D 07.06.06 added K642-511 EC
 Est Rev: E 07-12-05 ECN 1080p Rev L DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JND 08.7.08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-511CHG003

S 08/7/31

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 40237A FLOAT SKIDTUBE ASSEMBLY



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

1 x D206-642-541 Batch

40237A

sel

4.0 K642 511 saddle kit 642-511



37360



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

saddle kit 642-511

8/7/31

300

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/7/31

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 40237

Part Number: D206642511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-511

Location: C

PC 8/2/31 (1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/01 H

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-0730

40237A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Thursday, 7/3/2008 3:39:13 PM
 User: Kim Johnston

Process Sheet

29

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE ASSEMBLY
 Job Number : 40237A
 Estimate Number : 10309
 P.O. Number :
 This Issue : 7/3/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206642541
 First Issue : / / Type : SKIDTUBES Drawing Number : D3274 REV D
 Drawing Revision : D
 Previous Run : 40236A Material :
 Due Date : 7/17/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JA 080704
 Comment : Est Rev:B 05-09-23 Revised per D206-642 Rev. J KJ/JLM
 Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 Est Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 Est Rev:F 08-06-02 add comment DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A JA

2.0 D26001190 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-190 3" OD Tube

B 31032

BE 08/07/22

3.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274

BE 08/07/20

2- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

BE 08/07/22

3-Drill #40 Aft cap pilot hole using DT8025

4-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

BE 08-07-22

5-Remove inner indexing ridge on fwd and aft end of skidtube as per Dwg D3274

6-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod m/08096 AE 08/07/22

8-Grind welds flush to Fwd cap on top surface only.

AE 08/07/22

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI.005 4.1

AE 08/07/23

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/07/23 (u)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/07/23 (u)

7.0

D3282041

Float Web (206L/407)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web 237127

AE 08/07/23

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291 m/07888

Sikaflex expire date: 11/2008

Start: 1:30 Time: 08/07/23

Finish: 8/7/24 Time: 8:00 AM

(Adhere for 12 hours)

AE 08/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24 (20)

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

DP 8-7-24

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

BE 08-07-24

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24 (41)

12.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

B 33902

BE 08/07/22

13.0

D2649

Cross Bolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

B 39883

BE 08/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

335210

BE 08/07/24

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

M107877 BE 08/07/24

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

M 8-7-28

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/07/28

19.0

POWDER COATING

POWDER COATING



M108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15 OF
320
8:45

M. 08/07/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 08-07-29

21.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3415-041

Nut Plate

Batch

B33842

FL

22.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 CCR264SS3-3

Rivet

Batch

m106825

FL

23.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 CR3212-4-03

Rivet

Batch

m15918

FL

24.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Insert

Batch:

m105819

FL

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

AR/N/ALPS-3 *m104251*

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

> FL 08/07/29

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expire date:

m 107888
08/11

FL 08/07/29

①

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

S 08/07/29

27.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

BOLT

Batch:

m 108558

FL

28.0

D353515

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

637810

FL

29.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

639134

FL

30.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

637625

FL

31.0

D353539

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

637277

FL

32.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

633964

FL 08/07/29 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 133965

FL

34.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 136017

FL

35.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 133966

FL

36.0

D35371

Wearpad



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: 157749

FL

37.0

D35373

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: 150758

133881

FL

38.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer

17108672

FL

39.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 139275

FL 08/07/29 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

40.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

B33949

FL

41.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

M104936

FL

42.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer

M100993

FL

43.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

B37377

FL

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

Sikaflex expire date:

M107888

08/11

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch: M106096

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

FL 08/07/29 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 40237A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

m107888

Sikaflex expire date:

08/11

FL 08/07/29 (P)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/7/29 (+1)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

(12)

Identify and stock

Location:

PPP

8/7/31

510

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/01

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **[Signature]**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

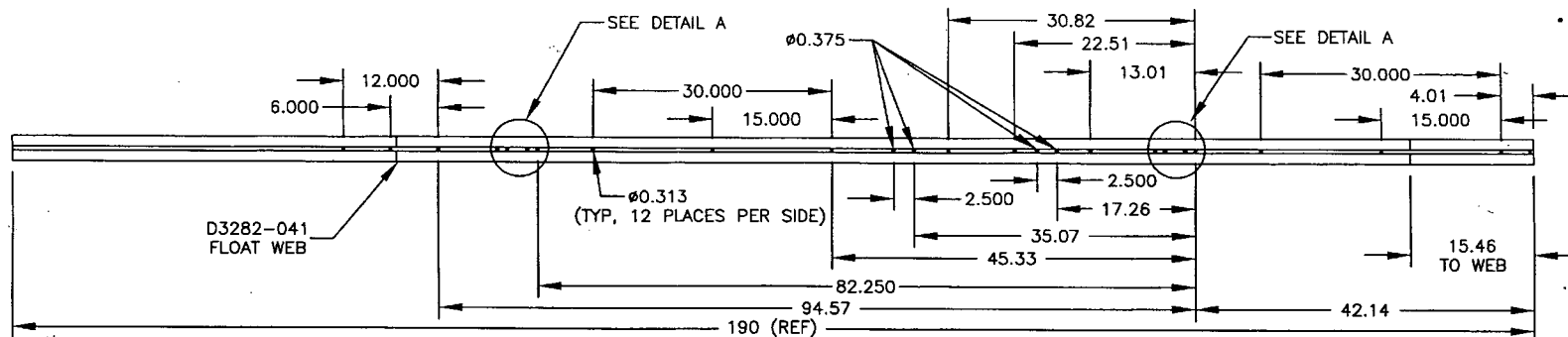
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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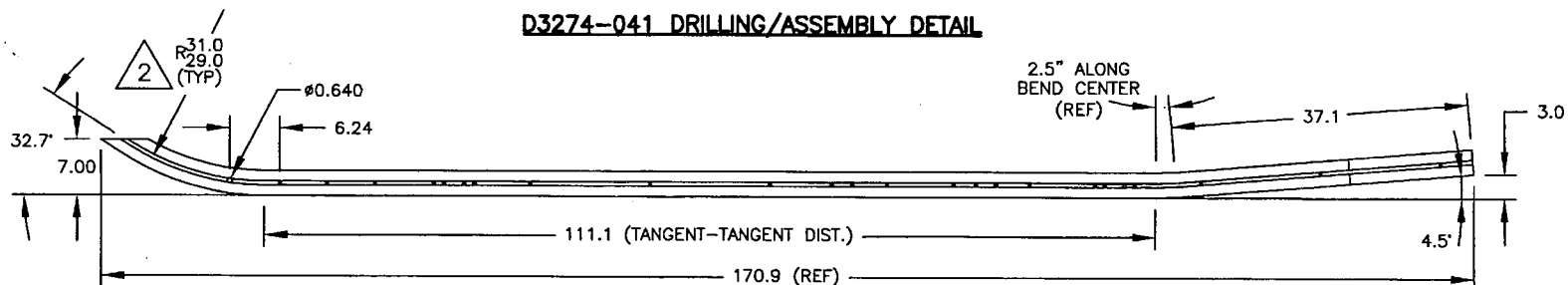
WORK ORDER
NO. **40231A**

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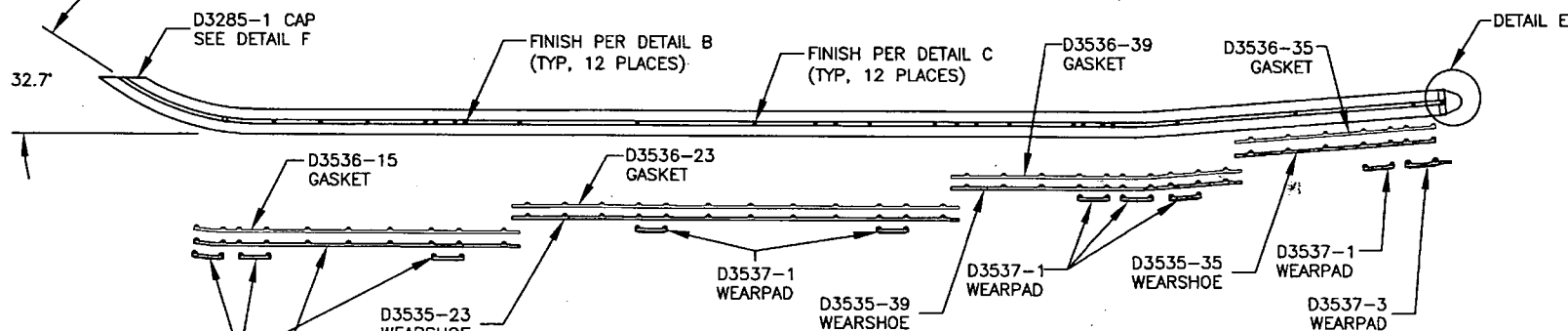
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

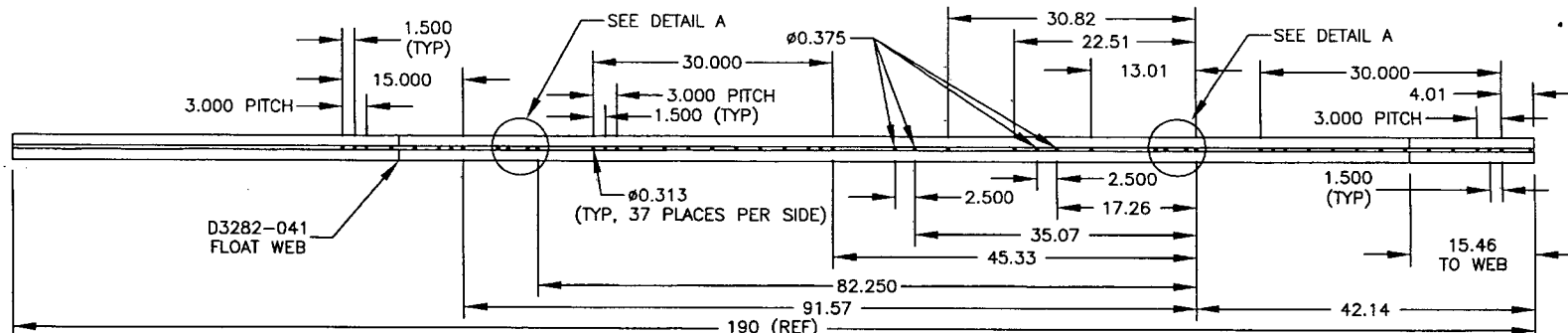
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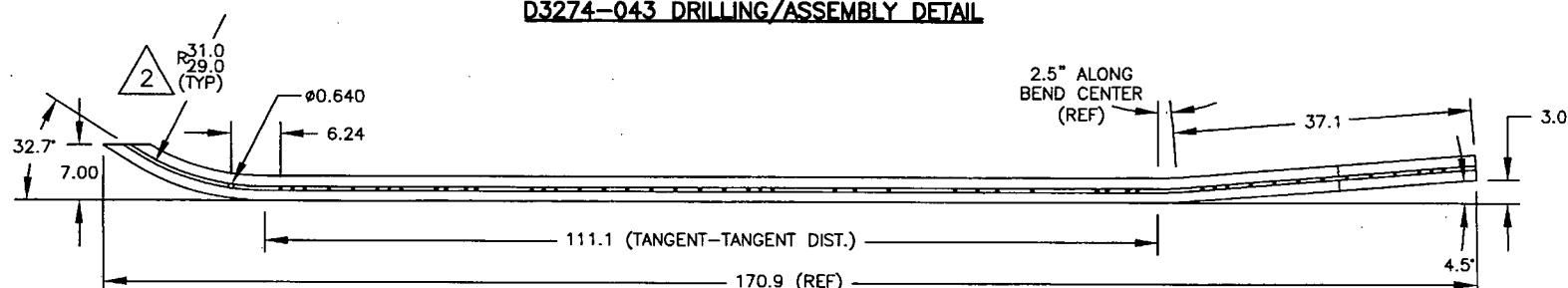
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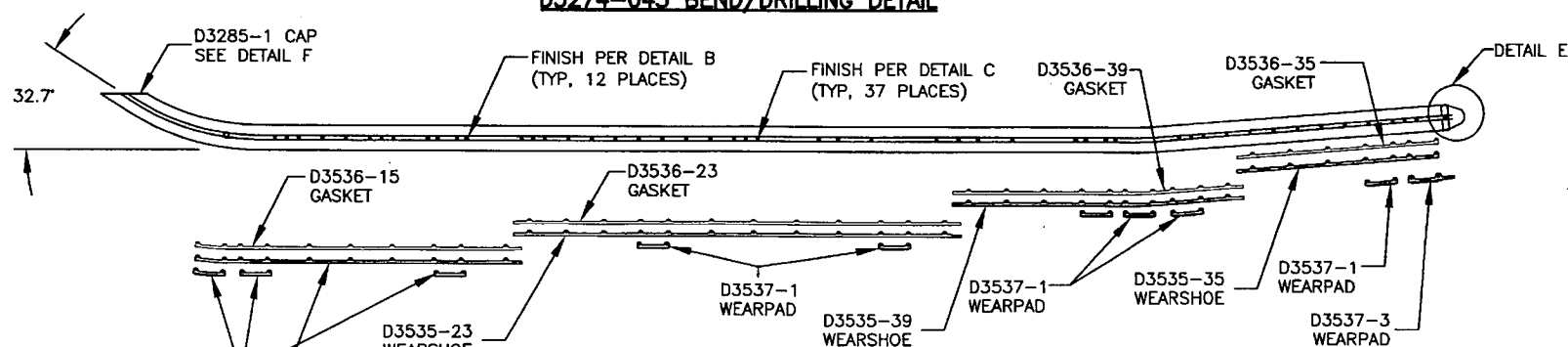
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CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

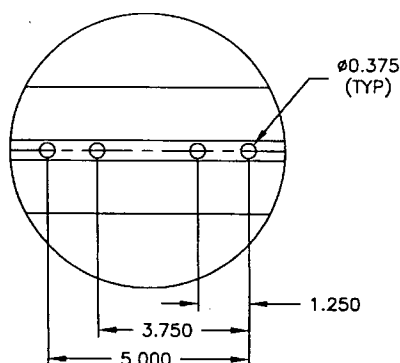
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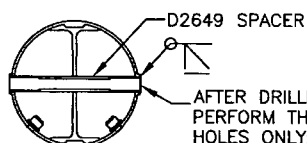
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DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

DETAIL A: DRILL DETAIL

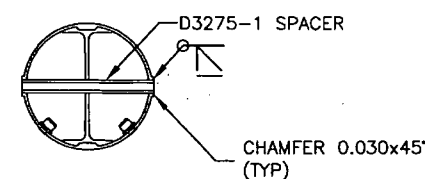


DETAIL B FOR 0.375 HOLES ONLY

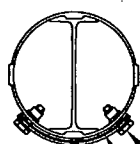


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

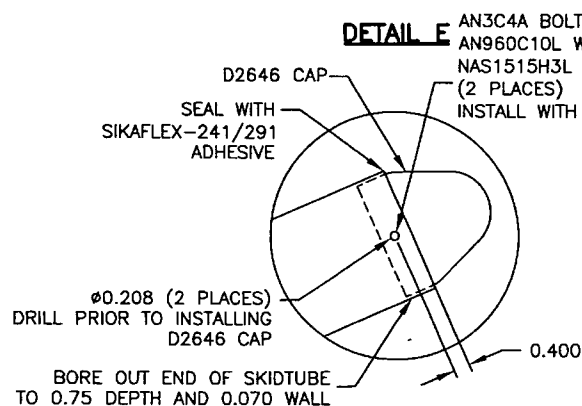


DETAIL D



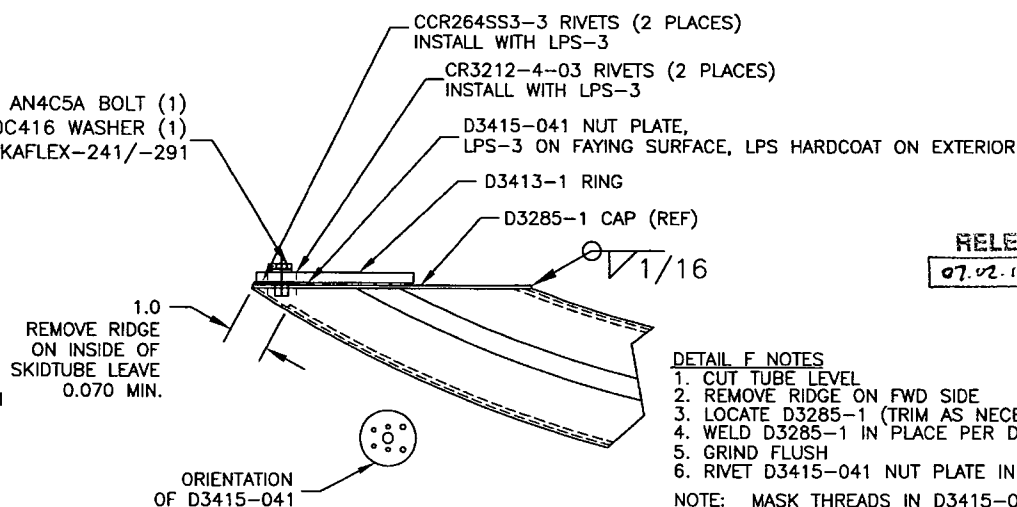
- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



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DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
07.02.12

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				D3274	SHEET 4 OF 4
				TITLE	SCALE
				SKIDTUBE ASSEMBLY	1:3

NO. 163

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 040394
Part number: D206 642 141
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pet. Duval Date of Test Coupon 08-07-11
Welder Barclay Elliot Date of Test Coupon 08-07-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld